Work Order				*07′	351*			-51	MA	<u> </u>	Page 1
Friday, February 1.		:57:26 PM			), ) I			<u> </u>	e) D		
Revision ID:	3876-11 otector - Flo	oor		Accept	*N90	0040	1100	* 5	Setup Star Sto	1.71	S1* S2*
	15/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Ite Custom					TN.	5/"
Approvals: P	rocess Pla	n: MF	Date: 13-249	Tooling:		Date:		F	Run Sta	1/1	R1*
Q	QC:		Date:	SPC (Y/N):		Date:			Sto	*N	R2*
Sequence ID/ Work Center ID	•	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			,						
D3876	A										
100				0.00							
*100*		FLOW WATER JET						6	٥		JM13-2-20
Waterjet FLOW CNC Waterjet		Dwg Rev: Prog Rev:	er Dwg D3876 if necessary	0.00							
110		QC2- Inspect parts off	machine FAI/FAIB	0.00							
*110* QC Quality Control		Memo		0.00				6	_6_	· · · · · · · · · · · · · · · · · ·	JM 13-2-20
120		QC8- Inspect parts - se	cond check	0.00							
*120* QC Quality Control		Мето		0.00					***	-	

NCR:	Yes	1	No
14011.	162	1	110

DQA: \_\_\_\_ Date: \_\_\_\_

NCR:	ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
										·		QA Closed:	Date:	1 -	
Nork Orde	or.						DISPOSITION				AGAINST DI	EPARTMENT/PROCESS			
WOIR OIG	٠, ,					١	Rework		Skid-tube Crosstube			7	Water Jet	Engineering	
Part N	lo.						Scrap			Machining Small Fab			d. Eng. Coor.	Quality	
	•	···			· · · · · · · · · · · · · · · · · · ·		Use-as-is			Thermoforming Finishing			e/Packaging	Other	
NCR No.				1	Work Order Update Large Fab				Composite	]	Supplier				
Root Descr				 rip	ription of work order update			Acti	ion	Sign &					
Cause		Date	Step	Qty		•	r Non-conformance	l	ief Eng	1	iption	Date	Verification	QC Inspector	
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		Bending					Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced	
	<u> </u>	Centre No	ot Concer	ntric to (	o/s  -	_	BOM/Route	-	Hardwa		_	Over/Under		Temperature/Cure	
		Cracks	. · ·		-	_	Broken/Damaged	<u> </u>	1	ion Incomplete		Part Incorred	<u> </u>	Weld	
	<u> </u>	Crushed/0	Crimped.		-	_	Burrs	-	-	tions Incomplete/U	unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs			-		Contamination	$\vdash$	Mainte		-	Part Moved	Mana		
		Heat Trea		T l		$\dashv$	Countersink	<u> </u>	Mislabe		-	Positioned V Power Loss/		Other	
		Inspection		iupe	-	-	Cut Too Short Drill Holes	-	Misread Offset	u	L-	Jrower Loss/	Juige	Other	
		Ripples in		- - -	,	_	Drawing	$\vdash$	₹	Calibration		<del> </del>			
		Torque W			' }		Finish	Out of Sequence							
	H " ' H				Folio	Outside Dimensions									
Wave/Twist in Tube Folio						1	Louiside	- CHITETISIONS							

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Page 2

Friday, February 15, 2013 2:57:26 PM Item ID: D3876-11 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Protector - Floor **Start Date:** 2/15/2013 Start Qty: 6.00 **Cust Item ID:** Required Date: 2/22/2013 Req'd Oty: 6.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Reject Plan Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 130 Identify as per dwg & Stock Location:\_ 0.00 \*130\* Packaging 0.00 Packaging 140 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo Quality Control

## WORK ORDER NON-CONFORMANCE / LIPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCN. 1	es / 1	U			WORK ORDER WORK	CONTO	TAIVIANCE / OI		QA Closed:	Date:	1 3	
Work Orde	r:				DISPOSITION			<b></b>	EPARTMENT/PROCESS			
Part N	o				Rework Scrap Use-as-is	- - - - - - -	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	→	Water Jet d. Eng. Coor.	Engineering Quality Other	
NCR N	o				Work Order Update	<u> </u>	Large Fab	Composite	Rec/Store/Packaging Other Supplier			
Root				Desci	ription of work order update	Initia	1 A	ction	Sign &			
Cause	Cause Date Step Qty c				or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector	
oc/Data												
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	Bend	•		_	Bend	Gra		-	Ovalized		Pressure/Forced	
		e Not Cond	entric to	O/S	BOM/Route	$\vdash$	dware	<u> </u> _	Over/Under		Temperature/Cure	
1	Crack			<u> </u>	Broken/Damaged	<b>—</b>	ection Incomplete	,, <u> </u>	Part Incorre	<u> </u>	Weld	
		ed/Crimpe	d.	_	Burrs	₩	ructions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
1	Cuffs	_		-	Contamination	$\vdash$	intenance	<u> </u>	Part Moved	**		
1	Heat			<u> </u>	Countersink	$\vdash$	abeled	}-	Positioned V		Jan	
		ction Strip	in Tube	<u> </u>	Cut Too Short	$\vdash$	read		Power Loss/	Surge	Other	
-		es in Bend		-	Drill Holes	Offs						
,		e Waves i		on	Drawing	$\vdash$	of Calibration					
	Turning Sequence				Finish	Out of Sequence						
	Wave	/Twist in T	ube	1	Folio	Out	side Dimensions					

Friday, February 15, 2013 2:57:26 PM

Work Order ID:

97351

Parent Item:

D3876-11

Parent Item Name:

Protector - Floor

**Start Date: 2/15/2013** 

Required Date: 2/22/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

				-5 5										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MLEXS.125-F60029-04		Purchased	No			100	sf	0.0000	11.11	70-168421		entra come a succession con		
GE PLASTICS LEXAN SH	EET									7		一丁	m (3-2-7	2

124655

124655

												DQA:	Da	ate:	
NCR: \	es ,	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE		·			
									•			QA Closed:	Da	ate:	٢ ,
\\1. O1.						DISPOSITION				AGAINST I	DE	PARTMENT,	PROCESS		
Work Orde	er: _				<del></del>	Rework	1		Skid-tube	Crosstube		[	Water Jet		Engineering
Part N	10					Scrap		1	Machining	Small Fab	_	Pro	d. Eng. Coor	$\vdash$	Quality
raiti						Use-as-is			noforming	Finishing			e/Packaging	$\vdash$	Other
NCR N	lo.					Work Order Update		1	Large Fab	Composite		1100,000	Supplie	-	
	_						j		о <u>Г</u>	, ,		1	• •		<b>!J</b>
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data															
Equip/Tooling														Ì	
Operator							İ					ļ			
Material														ļ	
Setup												ļ			
Other					_								:	-	
Process														ļ	
Supplier															
Training							ļ								
Unapproved							<u> </u>								
							AUL	LT CATE	GORY						
Landi					<del></del>	General		1		ľ		1		_	1 .
Bending						Bend		Grain				Ovalized			Pressure/Forced
	_	entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa				Over/Under			Temperature/Cure
	_	racks			<u>_</u>	Broken/Damaged	_	-	on Incomplete			Part Incorre			Weld
	Crushed/Crimped,				Burrs	_	4	ions Incomplete/	'Unclear		Part Lost/M	issing		Wrong Stock Pulled	
]	Cuffs					Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	97357
Description: Protector – Floor	Part Number:	D3876-11
Inspection Dwg: D3876 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype	Х	First Article	Prototype
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			,	<del></del>		-	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ıments
80.80	+/-0.030	80.80"	_		丁	Throng	·
19.24	· +/-0.030	19.244	_		T		
18.73	+/-0.030	18.73"	_		T		
18.51	+/-0.030	18.51	-		Τ		
25.42	+/-0.030	25.42	_		T		
27.86	+/-0.030	27.864	_		T		
53.46	+/-0.030	53.46"	_		ナ		
55.90	+/-0.030	55.90"	_		1_		
0.125	+/-0.010	O 186"	-		V	Janoi	
,							
bitter							
					<u> </u>		
Measured by:	Jm	Audited by:	15	<u> </u>	Prototype A	pproval:	N/A
Date:	13-2-20	Date:	1323	1		Date:	N/A

	Rev	Date	Change	Revised by	Approved
į	Α	09.07.29	New Issue	KJ de	W\
•				10	10

												DQA:	Date:	
NCR: Y	es	/ No					WORK ORDER NON-C	O	<b>VFOR</b>	MANCE / UPDATI		OA Clasadi	Date:	£
						_						QA Closed:	Date:	
Nork Orde	r'					١	DISPOSITION			Α	GAINST DE	PARTMENT/PROCESS		
Part N	-						Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo	· · · ·					Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				inishing mposite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	crip	tion of work order update		Initial Action			Sign &		
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
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	_	Bending					Bend		Grain		ļ	Ovalized	_	Pressure/Forced
		Centre No	t Concer	ntric to	o/s	-	BOM/Route	_	Hardwa			Over/Under	<b></b>	Temperature/Cure
	—-	Cracks					Broken/Damaged	_	1	on Incomplete	-	Part Incorred		Weld
		Crushed/0	Crimped,				Burrs	<u> </u>	4	ions Incomplete/Unclea	ar	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination	<u></u>	Mainte			Part Moved		
	$\dashv$	Heat Trea					Countersink	$\vdash$	Mislabe		ļ	Positioned V		<del>-</del> 1 .
	-	Inspection		Tube			Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n		Drawing		4	Calibration				
		Turning S	equence				Finish	Out of Sequence						
	Wave/Twist in Tube					Folio		Outside	Dimensions					

